



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

*MATTE BLACK
Black Sandtex*

D3414-041
Job Sheet 181536



Part No: D3414-041

Job Qty: 8 ea

Part Name: Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/31/18

Job Tracking No:

Due Date: 8/22/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	8/22/18	8/22/18	0.00	0.00	Start Up Waterjet		<i>SC 18/8/18</i>
100	Waterjet	8 pcs	8/22/18	8/22/18	0.00	0.60	Waterjet1		<i>SC 18/8/18</i>
120	QC	8 pcs	8/22/18	8/22/18	0.00	0.00	QC8		<i>AS 19-05-01</i>
130	Brake NC	8 pcs	8/22/18	8/22/18	0.05	0.45	Brake NC 1		<i>SB</i>
140	Large Fab	8 pcs	8/22/18	8/22/18	0.00	2.45	Large Fab 1		<i>18/8</i>
150	QC	8 pcs	8/22/18	8/22/18	0.00	0.00	QC9		<i>a</i>
160	QC	8 pcs	8/22/18	8/22/18	0.00	0.00	QC5		<i>2/19</i>
170	Powdercoat	8 pcs	8/22/18	8/22/18	0.00	0.17	<i>Powdercoat2</i> <i>MATTE BLACK</i>		<i>2/19-2-15</i>
180	QC	8 pcs	8/22/18	8/22/18	0.00	0.00	QC3		<i>19-02-21</i>
190	Packaging	8 pcs	8/22/18	8/22/18	0.00	0.00	Packaging3-1	<i>531</i>	<i>19-02-21</i>
200	QC21-SA	8 Ea	8/22/18	8/22/18	0.00	0.00	QC21		<i>19-02-21</i>

Part Op 100 - 1-Cut as per Dwg D3414-1 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 130 - 1-Deburr 2-Form using DT8254 as per Dwg D3414

140 - 1- Weld using location Jig DT9625 as per Dwg D3414 A/B S.S. welding rod Batch:

170 - START TIME: 9:35 OVEN TEMPERATURE: 320 FINISH TIME: 10:05

*DAE
21
2-09*

FEB 22 2019

M138940

FM138485

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S12GA	304/316 0.100" Sheet	1.2400 sf (.155 ea)	90-Start up Operation	
D3414-3	Lug	8 Ea (1 ea)	140-Large Fab	<i>5066276</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S12GA	1	55	0
140-Large Fab	D3414-3	8	53	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug Bracket	0.313inches + 0.006 - 0.001	0.319 0.312		
2	Lug Bracket	1.190inches ± 0.030	1.220 1.160		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																								
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Date :		Step #:		Part: D3414-041 Job No: 181536 Serial No/Batch: S099309 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 08/05/18 Approval _____ By _____ Supervisor _____ Coordinator _____ Container No: S099309 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																												
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4	Lug Bracket	3.380inches $\pm$ 0.030	3.410 3.350
5	Lug Bracket	5.350inches $\pm$ 0.010	5.360 5.340
6	Lug Bracket	6.230inches $\pm$ 0.030	6.260 6.200
7	Lug Bracket	2.500inches $\pm$ 0.010	2.510 2.490
8	Lug Bracket	0.370inches $\pm$ 0.030	0.400 0.340
9	Lug Bracket	0.100inches $\pm$ 0.010	0.110 0.090

Plex 7/31/18 1:29 PM Dart.lajeunesse.marie

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